

**Work Order ID 59441**

Friday, June 04, 2010 10:27:39 AM



Page 1

Item ID: D3912-1

Accept



Setup Start



Revision ID:

Item Name: Eyebolt

Stop



Start Date: 6/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: *K*Date: *16-6-04* Tooling:

Date:

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N):

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3912	A

100

0.00



Doosan

Memo

0.00

Doosan Lathe

TURN AS PER FOLIO FA871 AND DWG

Prog Rev: \_\_\_\_\_

Dwg Rev: *A*

Deburr as required

*SL 10/06/14 (12)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*SL 10/06/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

SF, 10/06/14

12

SF



QC

Quality Control

130

Identify as per dwg &amp; Stock Location: 96

0.00

10-6-15 12 SF



Packaging

Packaging

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00

10/06/15 SF



QC

Quality Control

Memo

0.00

R010-6-15  
(12)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Friday, June 04, 2010 10:27:43 AM

Page 1

Work Order ID: 59441



Parent Item: D3912-1



Parent Item Name: Eyebolt

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000  303 ROUND BAR 2"		Purchased		No		100	f	5.8400	0.25	3.157895			

Location      Loc Qty      Loc Code

MAT029	5.84	
113341	5.84	

3.0      SL      10/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59441
Description: Eye bolt	Part Number:	53912-1
Inspection Dwg: D3912 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.28	$\pm .030$	2.282	✓			
1.25	$\pm .030$	1.253	✓			
.625	$\pm .010$	.625	✓			
.13	$\pm .030$	.125	✓			
.015	$\pm .010$	.015	✓			
.13	$\pm .030$	.132	✓			
.500	$\pm .010$	.500	✓			
.700	$\pm .010$	.700	✓			
.90	$\pm .030$	.898	✓			
.13 x 45°	$\pm .030 \pm .5^\circ$	.140 x 45°	✓			
.800	$\pm .010$	.800	✓			
1.60	$\pm .030$	1.601	✓			
.625	$\pm .010$	.626	✓			
.438	$\pm .010$	.439	✓			
1.10	$\pm .030$	1.100	✓			
1.75	$\pm .030$	1.752	✓			
1.00	$\pm .030$	1.00	✓			
.30	$\pm .030$	.297	✓			
.88	$\pm .030$	.880	✓			
.11	$\pm .030$	.109	✓			
.719	$\pm .010$	.723	✓			
.13	$\pm .030$	.125	✓			
.397 $^{+.006}_{-.001}$	<del>.397 <math>^{+.006}_{-.001}</math></del>	.397	✓			
helical						

Measured by:	<u>JL</u>	Audited by:	<u>BB</u>	Prototype Approval:	N/A
Date:	10/06/20	Date:	10/06/14	Date:	N/A

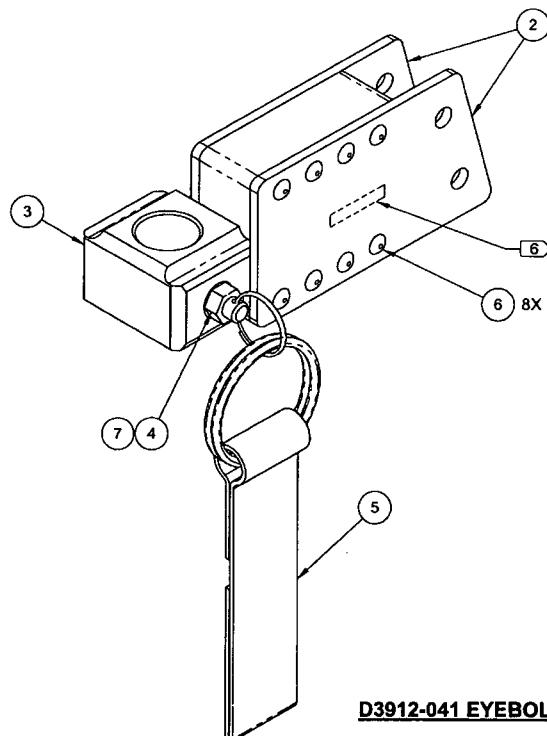
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY

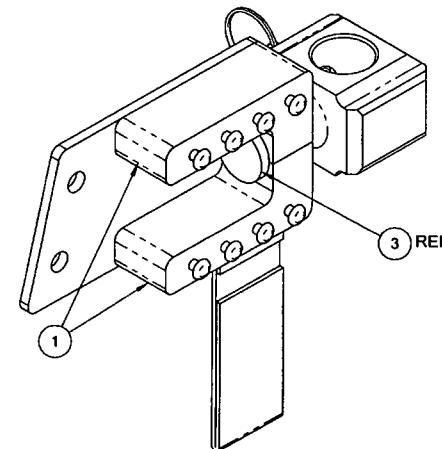
5 RETRIEVED

ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	2	D3912-3	EYEBOLT BLOCK
2	2	D3912-5	EYEBOLT PLATE
3	1	D3912-1	EYEBOLT
4	1	D3810-1	SPRING PLUNGER
5	1	D4028-041	SPRING PIN LANYARD ASSY
6	8	MS20615-4M20	RIVET
7	1	MS21209-C610	HELICAL (RED LOCKING)

ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 594141

*By 10-6-09*

D3912-041 EYEBOLT RECEIVER ASSY

SUPPLEMENTAL ISO VIEW  
(EYEBOLT PLATE REMOVED  
TO SHOW INTERIOR FEATURES)

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING  
    FINE POINT PERMANENT INK MARKER  
 7) WEIGHT -041: 1.68 lbs

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>pp</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>jj</i>	D3912	SHEET 1 OF 3
APPROVED	<i>jj</i>	TITLE	SCALE
DE APPR.	<i>jj</i>	EYEBOLT RECEIVER ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

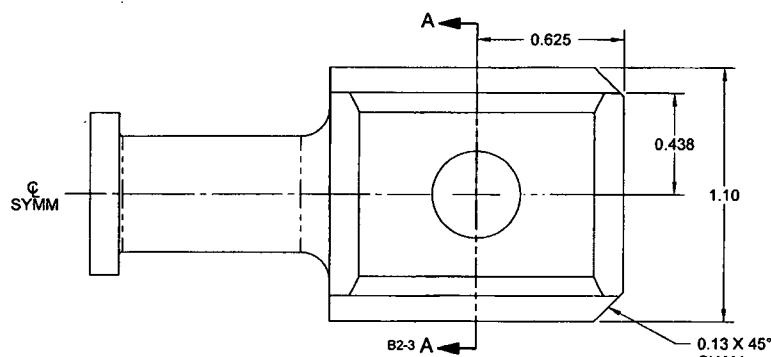
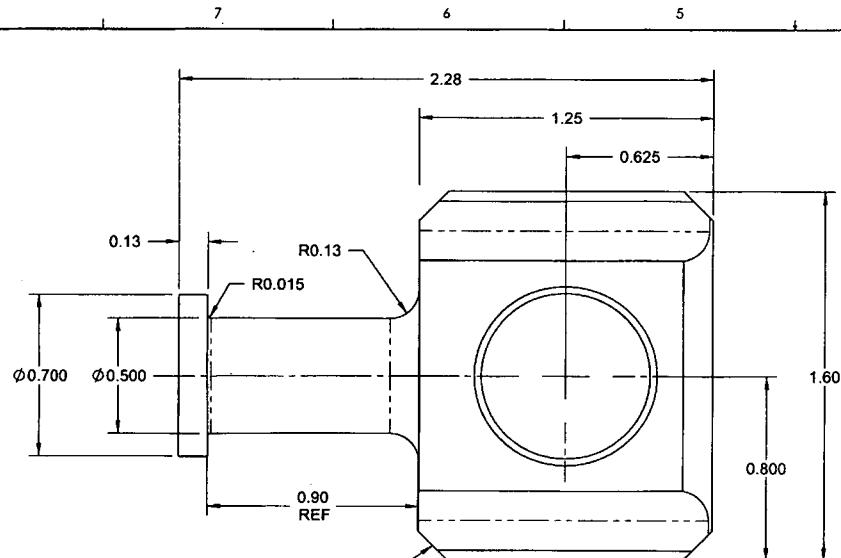
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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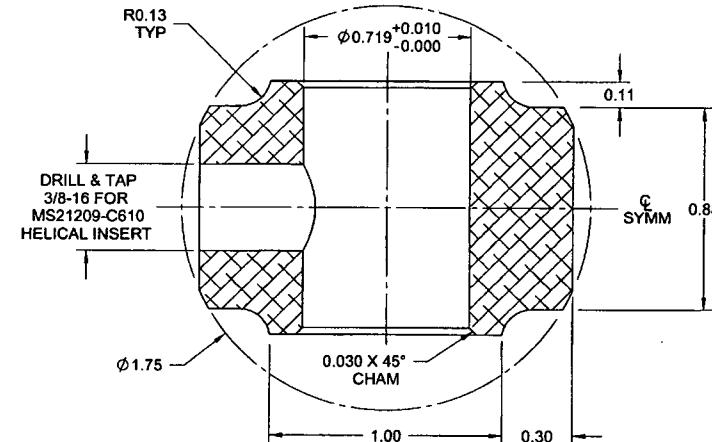
NOTE: Date & initial all entries



D3912-1 EYEBOLT

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.49 lbs



SECTION A-A B6-3

**RELEASED**  
2010-03-12  
JMP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	
MFG. APPR.	88	REV. A	
APPROVED	MP	D3912	
DE APPR.	#	SHEET 2 OF 3	
DATE	10.03.04	TITLE	
		EYEBOLT RECEIVER ASSY	
		NTS	

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

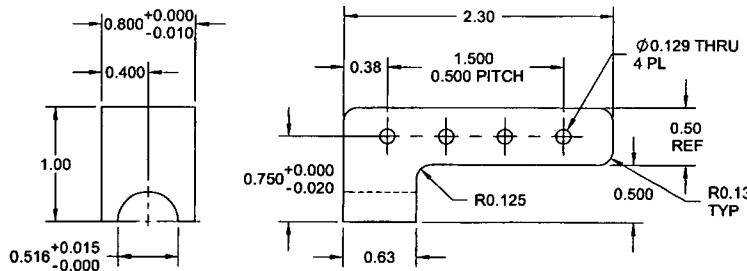
D

C

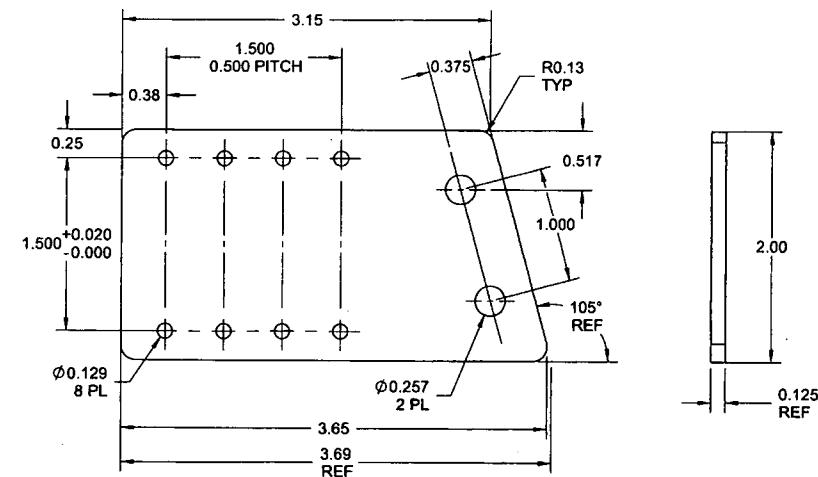
C

B

B



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

RELEASED  
2010-03-12  
NP

## NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240  
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs  
-5: 0.24 lbs

8 7 6 5 4 3 2 1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	g	DRAWING NO.	REV. A
MFG. APPR.	u	D3912	SHEET 3 OF 3
APPROVED	NP	TITLE	SCALE
DE APPR.	H	EYEBOLT RECEIVER ASSY	NTS
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